STI International, Inc.

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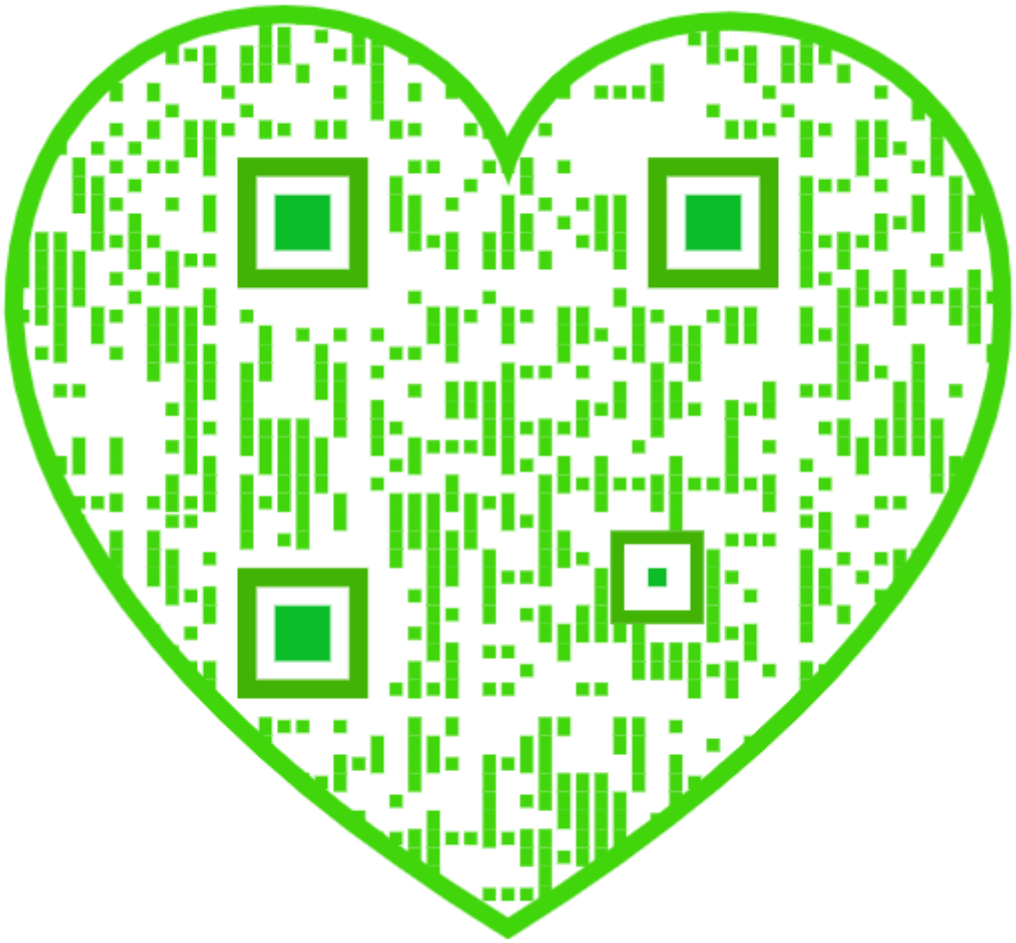
HANDGUN
SAFETY REFERENCE
and
OWNER'S MANUAL

•Trojan • Hunter • Ranger • Xcaliber • LS9/40 •BLS9/40•

ALL "1911" Style Firearms



Important Safety Information Inside

Read, Understand and Follow all instructions and safety rules inside this Manual before handling any STI series firearm. Improperly handled firearms of any kind represent a hazard to persons and property.

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Model and Serial Number Information

For your convenience, please record the following information.

STI Handgun Model: _____

Serial Number: _____

Barrel Length: _____ Caliber: _____

Date of Purchase: _____

Purchased From: _____

Receipt or Invoice Number: _____

Address: _____

City: _____

State: _____ Zip: _____

SAFE OWNERSHIP - THE NEED FOR INSTRUCTION

Warning!
Firearms have been determined by the United States Government to be dangerous and potentially lethal weapons subject to restrictions.

• Possession of this or any firearm indicates your acceptance of responsibility to comply with the law and prevent consequences of danger which can result from improper handling.

• STI International strongly recommends that every person receive complete and thorough instruction on the safe and proper use of firearms from a competent instructor before handling this or any other firearm.

• Those unfamiliar with firearms should not remove this STI product from its packaging until successfully completing a full course of instruction by a competent instructor on the safe use and handling of firearms with an emphasis on semi-automatic type handgun safety.

• Information on qualified instructors in your area may be obtained by consulting your local law enforcement authorities, a firearms retailer or through local gun clubs.

• Additional sources on firearms safety and instruction can be obtained by writing to national organizations, such as the United States Practical Shooting Association (USPSA - 903-A Metcalf Street, Sedro Woolley, WA 98284, or the National Rifle Association (NRA - 11250 Waples Mill Road, Washington, DC 22030, (703) 267-1430).

SAFE OWNERSHIP - GENERAL PRECAUTIONS

• Be prepared - Firearm safety depends on proper preparation. Always have the right gear and accessories available for handling a firearm. The key to safe firearm handling is to protect yourself against distractions and adverse conditions. Proper planning and equipment will allow you to handle your firearm in a comfortable manner. And give you the ability to focus on safety.

• **Protect your hearing -** Firearms produce high noise levels when discharged. Protect your hearing from potentially harmful exposure with an adequate sound attenuation product, such as ear plugs and/or ear muffs. Unprotected exposure to loud noises can cause a loss of hearing known to have a cumulative effect and can cause permanent hearing loss.

• **Protect your eyes -** Firearms as well as environmental conditions can affect your eyes if not properly protected. Always protect your eyes with impact-resistant glasses. Use corrective lenses if necessary to clearly see your firearm and your target. Tinted lenses should only be used under proper lighting conditions. Eye protection should provide adequate protection against airborne debris, hot gases, powder blow-back, ejected shell cartridges, dust, wind, sun glare, low limbs or any other condition that could endanger yourself or others nearby.

• **Protect your body -** Wear adequate clothing to help protect your body from injury. Your body should be protected from firearm discharge and ejected shell cartridges, which are hot and could cause burns. Be certain to wear comfortable, well-fit clothing appropriate to the season. Do not wear clothing which causes discomfort or could impair the safe handling of a firearm.

• **Be responsible -** Firearm safety depends on you. A responsible owner respects the right and privilege of gun ownership. A responsible firearms owner learns and obeys all firearm safety practices, and always considers every firearm to be loaded. Stay aware of the fact that you have a responsibility for your own safety and the safety of others around the firearm.

SAFE OWNERSHIP - CHILDREN AND FIREARMS

WARNING!

Keep firearms away from children. Avoid conditions which could allow a firearm to be unexpectedly discovered by a child. Keep firearms and ammunition under lock, out of sight of, and beyond the reach of children.

Children should be made aware of the danger presented by improperly handled and stored firearms and must be given instructions to report any unexpected discovery of a firearm to a responsible adult.

Minors and adolescents **SHOULD NOT** have access to firearms without proper adult supervision. Keep firearms and ammunition locked away in a safe place, inaccessible to any minor or adolescent. The parent, guardian, or legal adult supervisor should be aware of the laws and restrictions regarding the use of a handgun by a minor or adolescent, and should use proper judgment regarding such use. The legal adult supervisor should realize the additional responsibility of a minor with a firearm and be certain to provide close, competent instruction prior to using this or any other firearm. Be sure to remind minors and adolescents that firearms differ from toys and are not to be used in play.

SAFE OWNERSHIP
THE BASIC RULES OF FIREARM SAFETY

1. Do not rely on your firearm's safety mechanism. Treat every firearm as if it were loaded, and ready to fire, at all times.

2. Never point your firearm at anything you do not intend to shoot. Always keep the muzzle pointed away from other people, and in a safe direction.

3. Always check the barrel for obstructions. Use only ammunition of the proper type for the firearm you are using.

4. Do not shoot unless you are absolutely sure of your target and what exists beyond it.

5. Never shoot at a hard surface or the surface of the water. Make sure you have a safe backstop.

6. Never drink alcoholic beverages or take drugs before or during shooting.

7. Never leave your firearm unattended until you have unloaded it and secured it from unauthorized handling and use.

8. Never carry a loaded firearm when you climb a tree, cross a fence, jump over an obstacle, or go across area where you are likely to trip, slip, stumble or fall.

9. Carry only empty firearms when traveling between destinations.

10. Store firearms and ammunition separately, out of sight of and beyond the reach of children, minors, and adolescents.

YOUR NEW STI HANDGUN - GENERAL DESCRIPTION

Overview…
An STI handgun functions as a single-action, blow-back recoil , automatic loading firearm - more commonly referred to as 'semi-automatic.' A semi-automatic firearm will fire a single ammunition round and automatically reload another round into the chamber with each pull of the trigger. All STI model handguns will continue this reloading operation until all ammunition rounds have been emptied from the magazine and there is no remaining supply from which to chamber a new round. The slide will remain open after the last round has been fired from the handgun.

Components for safety…
STI handguns have a mechanical Grip Safety and a Thumb Safety device to assist you in the safe handling of the firearm. These features, when engaged, provide additional protection against Accidental Discharge by preventing the trigger from releasing the hammer and striking the firing pin.

The Grip Safety assists in preventing the handgun from firing without the Grip Safety being depressed.

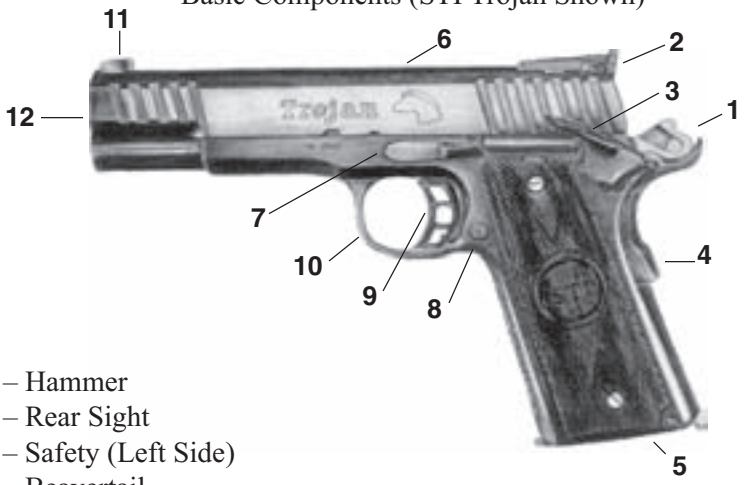
The thumb Safety locks the slide and restricts movement. The thumb safety also prevents the sear from disengaging the hammer allowing the hammer to strike the firing pin. On some STI models, the Thumb Safety can be operated from both sides of the handgun, and is referred to as an ambi-safety. The Thumb Safety can only be engaged with the hammer in the cocked position ready to fire.

Note: Safety systems provide only a limited amount of protection, and – like any mechanical system – can malfunction unexpectedly.

Do not load the STI "1911" model handguns with ammunition before reading all the Safety Instructions and Basic Rules of Firearm Safety (page 5 of this owner's manual).

YOUR NEW STI HANDGUN - BASIC COMPONENTS

Basic Components (STI Trojan Shown)



1 – Hammer
2 – Rear Sight
3 – Safety (Left Side)
4 – Beavertail
5 – Frame (Magazine Port Area)
6 – Slide (Ejection Port on opposite side)
7 – Slide Stop
8 – Magazine Release
9 – Trigger
10 – Trigger Guard
11 – Front Sight
12 –Barrel (Muzzle End)

YOUR NEW STI HANDGUN - BASIC COMPONENTS

STI International produces a number of different models of semi-automatic handguns in various calibers. To identify an STI handgun model, look at the engraving on the left side of the firearm. It includes the model's name and, sometimes, a number, which represents the barrel length. The caliber and type of ammunition to be used with an STI handgun is engraved on the barrel. (Some barrels may have the barrel supplied with generic caliber markings of .355 or .400. The .355 includes 9mm Luger, 9x21, 9x25, and 38 Super while .400 includes .40 S&W, .40Super, and 10mm. Please refer to page 2 of this manual, consult a qualified gunsmith or contact STI International to confirm the specific caliber of any barrel. Do not attempt to load or fire a firearm until you have confirmed specific caliber.)

Safe and proper use of this handgun requires full knowledge and understanding of each component and mechanical feature. Refer to the view at the left.

Before Loading this Firearm…

• Learn to recognize and identify each of the functional components of this STI firearm.
• Understand how to safely operate this firearm by carefully reading the instructions on the following pages.
• Follow each step for operating this STI firearm as described in this manual with the chamber empty, the magazine removed, and the muzzle pointed in a safe direction.
•Practice operating the firearm with it unloaded. Continue your practice until you have become familiar with the firearm functions and can comfortably handle the firearm in a safe manner.
• Repeat these steps frequently to assure safe shooting conditions.
• Review this manual of operation and safety instructions periodically. If you have not handled this or any other firearm recently, be certain to review this manual before you load this firearm with live ammunition.

YOUR NEW STI HANDGUN - AMMUNITION

WARNING!
Always keep firearms and ammunition out of the sight of and beyond the reach of children. Do not load this or any other firearm with live ammunition while learning the firearm's operation.

Before Loading Any Firearm With Ammunition…
• Check your ammunition to be certain that the caliber matches the caliber of your firearm. Commercially-manufactured ammunition has the caliber number clearly stamped around the rim at each end of the cartridge. Every STI handgun has the firearm's caliber (or a generic marking, in the case of the .355 and .400 barrels – see page 9) engraved on the barrel.
• Do not shoot this firearm if you question the compatibility of the ammunition you are using. Do not use unmarked or hand-loaded rounds of unknown origin. Use only clean, dry, original high-quality commercially-manufactured ammunition in good condition.
• Do not use ammunition with split, crushed, or dented casings or bullets which show sign of damage.
• Remove unfired ammunition from firearms immediately after use and return to proper storage containers.
• Always keep ammunition away from heat and flame.

STI handguns can be safely fired using factory specification standard velocity ammunition. STI accepts no responsibility for claims brought against the company due to any other loads or any loads which do not meet the safety tolerances endorsed by the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI).

PREPARING TO FIRE - GUN HANDLING & PREPARATION

WARNING!
Do not rely on your firearm's safety mechanism. Treat every firearm as if it were loaded, and ready to fire, at all times.

When Reaching for any Firearm…
• Do not reach for any firearm by the muzzle end.
• Never accept anyone's word that a firearm is unloaded when receiving it from them - always check for an empty chamber.
• Always check for an empty chamber by opening a firearm's action. Note: STI model handguns must be checked by first removing the ammunition magazine from the firearm to prevent a round from entering the chamber.

Before Shooting any Firearm…
• Check the condition of the firearm. Check the firearm for cleanliness and smooth operation. Do not use a dirty or wet firearm, or one that has been excessively oiled or greased. An unclean firearm can become dangerous hazard when fired.
• Consult a physician when taking medications to be certain that your senses will not be impaired, and that your judgment will not be affected, so that you will be able to safely handle and shoot a firearm.
• Check your backstop.

WARNING!
Never drink alcoholic beverages or take drugs before or during shooting.

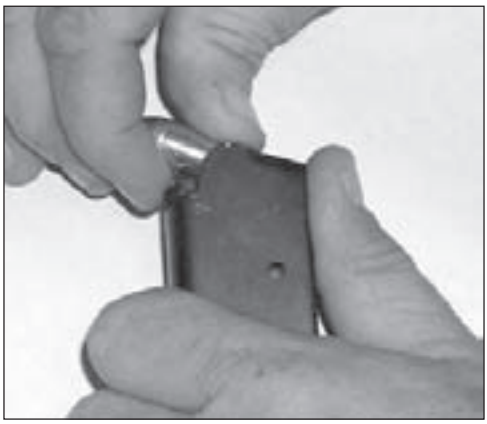
PREPARING TO FIRE - LOADING THE MAGAZINE

Preparing the handgun for firing is composed of three basic steps: Loading the magazine, Inserting the magazine, and Loading the Handgun Chamber.

WARNING!
Load magazines carefully. Avoid dropping the magazine or the ammunition, as damage or an accidental discharge can occur. Load magazines in a work area where accidentally dropped round can be found easily, above a work surface that is of a comfortable height and located in an area free from distractions.

1. Hold the magazine with the feed lips up, and the loading opening pointing outward, as shown below.

2. With your shooting hand, carefully insert a round through the loading relief, pressing down and to the rear of the magazine until the round is properly positioned. The primer end of the case should be in contact with the rear wall of the magazine. Repeat until the magazine is full.



PREPARING TO FIRE - INSERTING THE MAGAZINE

WARNING!
Keep the muzzle pointed away from yourself and in a safe direction. Do not use magazines that show signs of damage, cracking or excessive wear. Consult a qualified gunsmith if the magazine binds, fails to seat fully and securely, fails to release smoothly, or loads ammunition into the chamber of the handgun erratically.

1. Check for dirt and debris in the magazine port, and clean or clear as needed.

2. Securely hold the handgun with your shooting hand, with the magazine port pointing down as shown.

3. Insert the tip of the magazine into the magazine port of the handgun, with the ammunition feed opening pointing to the front of the handgun and the body of the magazine angled to match the angle of the grip as shown above.

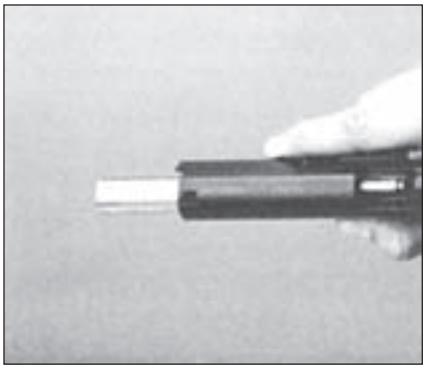
4. Push the magazine into the magazine port until it is firmly seated and the magazine retainer locks into place.

PREPARING TO FIRE - LOADING THE CHAMBER

WARNING!

Keep the muzzle of the handgun pointed away from anyone and in a safe direction. For this operation, the Thumb Safety must be in the READY or FIRE position and the handgun will be capable of firing a round. Your finger must be off the Trigger and outside of the Trigger Guard unless directed to do otherwise by these instructions.

1. Pull the slide fully back and inspect the chamber for dirt or debris. If the chamber needs cleaning or clearing, push the Slide Lock UP to hold the slide open.
2. load the chamber by releasing the Slide Lock and allowing the slide to snap back into position on its own. Do not interfere with its forward movement.
3. set the Thumb Safety to the SAFE position until you have chosen a target and are prepared to fire the handgun.



FIRING THE HANDGUN - GENERAL PRECAUTIONS

WARNING!

Don't shoot unless you are absolutely sure of your target and what exists beyond it. Always keep the muzzle pointed away from yourself and in a safe direction. Until you have chosen a target and are prepared to fire the handgun, keep the Thumb Safety in the SAFE position.

Before firing your STI handgun for the first time…
To assure safe, trouble-free performance beginning with the first time you fire your STI handgun, follow the cleaning and lubricating instructions on page 32 of this manual.

To assure safe firing conditions…
• Always handle a loaded firearm responsibly.
• Follow all safety precautions and customs of firearm safety at all times.
• Always keep the muzzle pointed away from anyone and in a safe direction.
• Always have the thumb safety set to SAFE when the handgun is cocked and ready to fire.
• Never release the thumb safety until you have aimed your handgun at your intended target and are ready to fire.
• Always position yourself sufficiently away from other people to assure everyone's safety when firing.
• Always squeeze the trigger slowly and deliberately towards you with your index finger when firing. Do not pull the trigger abruptly, in a jerking motion, or use another finger, under any circumstances.
• Never shoot any firearm in an unstable stance or position.
• Never drink alcohol or use other drugs before or during a shooting session. In the case of prescription medications, consult your doctor about possible side-effects that could interfere with your ability to safely handle a firearm.
• Never shoot at a hard surface or at the surface of water. Make sure you have a safe backstop.

FIRING THE HANDGUN - IN CASE OF MALFUNCTION

WARNING!
Never attempt to remedy a malfunction yourself before completing a course of training by a qualified instructor.

• Malfunctions occur from improper firearm handling, defective ammunition, or from damaged parts. A malfunction can be recognized by the improper feeding or ejection of a round of ammunition - a condition otherwise known as a "jam".
• The remedy of malfunctions requires specialized training and should not be attempted without first completing a full course of instruction by a person qualified in the safe use of semi-automatic handguns.
• STI International assumes no responsibility for malfunctions which occur from user abuse, neglect, or failure to follow the warnings and instructions in this manual.
• Never attempt to remove an ammunition round or casing from the chamber or ejection port with your finger.
• Never use excessive force to remedy a jam or attempt to remove a stuck round with a tool or object which can damage a firearm or set off a live round of ammunition.

WARNING!
Always have any firearm that malfunctions examined by a qualified gunsmith.

FIRING THE HANDGUN - IN CASE OF MISFIRE

WARNING!
Never point your firearm at anything you do not intend to shoot. Always keep the muzzle pointed away from people and in a safe direction.

Should a firearm fail to fire…
• Always keep the muzzle pointed in the direction of your target. An ammunition round can have delayed ignition, called a "hang fire", and can fire unexpectedly - up to a minute - after being struck by the firing pin.
• Always remove the ammunition magazine first, before attempting to determine the cause of misfire. Check the ammunition for proper type. Inspect the primer for firing indentation, to determine whether or not the firing pin engaged the primer, or if the firing pin hit the primer firmly.

• Never rechamber damaged or misfired ammunition. Keep them separate from other rounds.
• Never shoot any firearm if it continually misfires or malfunctions. A firearm that consistently misfires or malfunctions should be examined by a qualified gunsmith.

WARNING!
Always check the barrel for obstructions. Use only ammunition of the proper type for the firearm you are using.

CLEARING THE HANDGUN
REMOVING THE MAGAZINE

Clearing the handgun is composed of two basic steps: Removing the magazine and Unloading the chamber.

WARNING!
Until you pull the slide back and check for a remaining round in the chamber, the handgun is still LOADED and capable of firing a round. Keep the muzzle pointed away from yourself and in a safe direction. Your finger must be off the trigger and outside the trigger guard.

1. Make sure that the Thumb Safety is in the SAFE position.
2. Hold the handgun in your shooting hand, and place your other hand underneath the grip area to receive the magazine as shown below.
3. Fully depress the magazine release. The magazine should slide out of the handgun freely.

CLEARING THE HANDGUN

WARNING!
Keep the muzzle of the handgun pointed away from anyone and in a safe direction. The Thumb Safety must be in the READY or FIRE position and the handgun is capable of firing a round. Your finger must be off the trigger and outside of the trigger guard until you confirm the ammunition magazine is removed and the chamber is empty.

1. With the muzzle pointed away from yourself and in a safe direction, release and remove the ammunition magazine, pull the slide back and move the slide stop UP to keep the chamber open. If there was a round in the chamber it should eject with the opening of the slide.
2. Inspect the chamber. If there is a round in the chamber, carefully remove it and place it in a appropriate storage container.
3. Release the slide stop and slowly close the slide only after confirming the ammunition magazine is removed and the chamber is empty.
4. With the muzzle pointed away from yourself and in a safe direction, depress the trigger to release the hammer.
5. If you are finished shooting, have confirmed the ammunition magazine is removed and the chamber is empty, remove any remaining ammunition from the magazine.
6. Store the ammunition, the handgun, and the magazine in appropriate storage containers.

WARNING!
Until the magazine is removed and the chamber is empty, the handgun is still LOADED and capable of firing a round. Keep the muzzle pointed away from yourself and in a safe direction. Keep your finger outside the trigger guard and OFF the trigger.

CARRY AND TRANSPORT

WARNING!
Carry only empty firearms when traveling between destinations.

Before carrying or transporting any firearm…
• Always remove the magazine and check the firearm for an empty chamber before carrying or transporting. Note: STI model handguns must be checked by first removing the ammunition magazine from the firearm to prevent a round from entering the chamber.
• Never carry any firearm with the hammer in the cocked or half-cocked position. Keep the hammer forward, with the chamber empty, until you are ready to shoot.
• Always carry firearms in a case or holster specifically made for the type of firearm you are using until you are ready to fire.
• Never carry any firearm with your finger on the trigger or inside the trigger guard.
• Never carry any firearm by the muzzle end.
• Always keep any firearm's muzzle pointing in a safe direction when carrying it or preparing to shoot. Remain alert at all times. Be aware of how you could prevent an accident in the event of a stumble or fall by keeping the muzzle pointing away from any person or object that could be endangered.
• Avoid dropping your firearm under any circumstances.

WARNING!
Never carry a loaded firearm when you climb a tree, cross a fence, jump over an obstacle, or go across areas where you are likely to trip, slip, stumble or fall.

STORAGE

WARNING!
Never leave your firearm unattended until you have unloaded it and secured it from unauthorized handling and use.

Before storing or leaving this firearm unattended…
• Immediately remove the ammunition magazine from the firearm and check for an empty chamber. Note: STI Hunter‰, Ranger‰, Trojan‰, Xcaliber‰ and LS‰ model handguns must be checked by first removing the ammunition magazine from the firearm to prevent a round from entering the chamber.
• Remove all unfired ammunition from the firearm, the magazine, clothing, and from around the shooting area. Place unfired ammunition in a safe and separate location from the firearms.
• Place the unloaded firearm in an appropriate storage case or holster.
• Keep this and all firearms securely locked up and out of sight, away from any possibility of unauthorized access or unexpected discovery, unto ready to use.
• Always remain aware of the danger of firearms, even when stored.
• Check firearm storage frequently, to be certain the location remains secure and has not been violated in any way.

WARNING!
Store firearms and ammunition separately, under lock and out of the sight of and beyond reach of children, minors, and adolescents.

HANDGUN MAINTENANCE - DISASSEMBLY

WARNING!
Always remove the magazine and any ammunition in the firearm's chamber before disassembly. Always wear safety goggles during disassembly and reassembly to protect your eyes while handling spring-loaded parts.

General preparations…
• Choose a clean, stable surface at which to comfortably disassemble the firearm. Allow sufficient room to place the parts removed from the firearm without interfering with the disassembly process. To prevent damage to the firearm, disassemble the firearm on a clean, lint-free cloth.
• Read through the entire disassembly procedure before attempting to disassemble any of the STI model handguns.

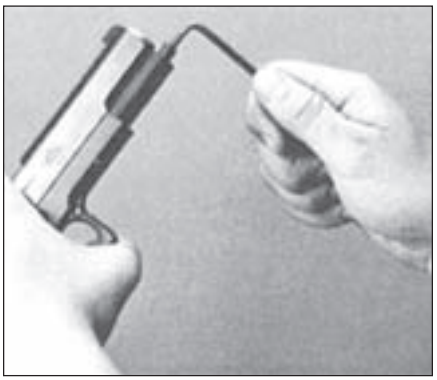
• The following disassembly procedure requires manual dexterity and specific tools. Seek the service of a qualified gunsmith for assistance if you are uncertain of your ability to perform the following disassembly process.
• Contact STI International for further clarification or instructions should any of the parts or assemblies shown in the disassembly process of this manual appear different from those found on your STI model.

Tools and supplies:
Your STI handgun is a precision assembly. Only high-quality tools and supplies should be used when working on it.
Safety goggles
5/32" Hex wrench
1/8" Dia. Steel punch
Lint-free cloths
Small non-marring hammer (optional)

HANDGUN MAINTENANCE - DISASSEMBLY

Outer Guide Rod Removal

1. Insert 5/32" Hex wrench into the hex head of Outer Guide Rod below the muzzle. Loosen the Guide Rod by turning counter-clockwise.
2. Remove Outer Guide Rod from the handgun by pulling the Rod out of the handgun towards the muzzle end.



Note: Most STI models have a one piece guide rod assemble. When holding the slide to the rear, place a pin in the small hole in the guide rod. Allow the slide to slowly move forward until the spring cap catches on the pin. The guide rod assembly will be captivated and will remove as one unit. Be careful when handling the unit as it is under spring tension.

Note: See additional instructions for "LS" and "BLS"

HANDGUN MAINTENANCE - DISASSEMBLY

Slide stop removal

1. Holding the handgun by the grip with one hand, firmly grasp the handgun's slide at the rear and pull the slide back. Be careful not to release pressure on the slide or allow the handgun to slip from your grasp. Pull the slide back until the disassembly notch on the slide (the second notch from the muzzle end) aligns with the rear of the slide stop on the left-hand side of the handgun.

2. While maintaining the slide disassembly notch alignment with the slide stop, remove the slide stop by pushing against the extended portion of the stop, located on the right-hand side of the handgun.

TIP: Maintain a firm grasp on both the slide and frame to prevent any movement. Pressure can be released from the slide once the slide tops has been removed.

Slide Assembly Removal

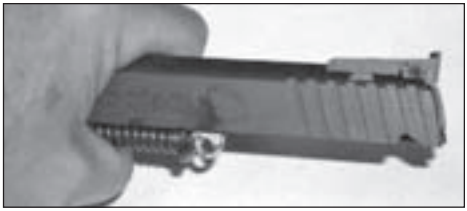
CAUTION:
Wear eye protection! The next two steps require the removal of a spring under compression.

1. Remove the slide assembly from the handgun frame while maintaining a firm grip on the handgun.
2. Restrain the recoil spring with the fingers of the hand holding the slide to prevent the spring form leaving the slide assembly. The recoil spring will be exposed at the underside of the slide as the entire assembly moves forward and off the frame of the handgun. Set the handgun frame aside after removing the slide assembly.

Spring and Guide Rod Head Removal from Slide Assembly

1. Turn the slide assembly upside down, carefully restraining the recoil spring under tension. Compress the recoil spring by grasping the guide rod head and carefully withdraw both from the slide releasing the spring tension. Lift the spring with the guide rod head from the slide assembly using fingers to grasp the spring. Pull towards the back of the slide to remove it from the handgun.
2.

TIP: Work slowly. This step may require some practice.



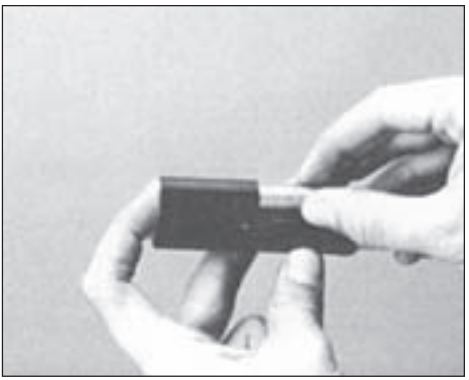
Captive Reverse Plug Removal from Slide Assembly

1. Push the captive reverse plug from the muzzle end of the slide assembly far enough back to be able to grasp the reverse plug and remove it from the slide assembly.

TIP: The reverse plug may sometimes be seated firmly, requiring assistance from a light hammer and punch tool to release it from the slide assembly. Tap lightly with the hammer and punch from the muzzle end of the slide.

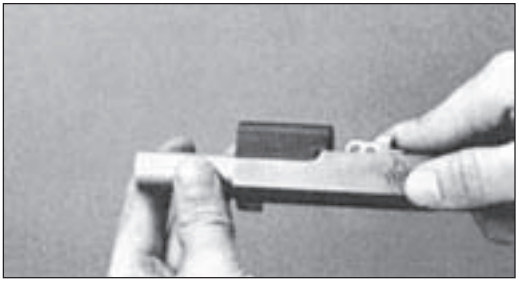
Barrel Removal

1. Hold the slide assembly upside down and rotate the barrel link to the forward position.



Note: The barrel cannot be removed from the slide assembly without the barrel link in the forward position. Always do this procedure before attempting to remove the barrel, to prevent damage to the slide.

2. Continue holding the slide assembly upside down. Gently lift the barrel with a finger through the ejection port and slide the barrel out of the muzzle end.



Firing Pin Removal

CAUTION:
Wear eye protection! This step requires the removal of a spring under compression. Before removing the firing pin and stop, position the slide with the firing pin pointing in a safe direction. The firing pin can eject from the slide unexpectedly and cause injury.

1. Firmly grasp the rear end of the slide and depress the end of the firing pin with a 1/8" punch tool. Push down on the firing pin sufficiently to release it from the hole in the firing pin stop. Place a finger of the hand holding the slide over the firing pin to retain the firing pin while removing the firing pin stop, to prevent the firing pin from ejecting from the slide.

TIP: This can be done in one motion by rotating the punch tool within the hole of the firing pin stop, using it to move the hole away from the firing pin.

2. Remove the firing pin stop by sliding the stop off the slide rails which retain it.

3. Slowly release pressure on the firing pin. The firing pin can be removed, once all the pressure has been released.

4. Remove the firing pin spring from the firing pin by turning the firing pin clockwise and pulling off the spring.

Extractor Removal

1. Firmly grasp the back of the slide with the muzzle end towards you and the underside of the slide facing up. Press firmly against the front of the extractor using a 1/8" punch tool. Push the tip of the extractor towards the side of the breach while depressing the extractor tip, until the extractor passes the extractor hold located at the back of the breach face.

2. Turn the slide around so the rear of the slide faces up, exposing the back end of the partially-removed extractor. Pull the extractor from the back of the slide. Use the punch tool as required to assist in releasing the extractor from its position.

HANDGUN MAINTENANCE - GENERAL CARE

The STI semi-automatic model handguns must be clean and properly lubricated to function reliably and maintain optimum performance and accuracy. Proper maintenance can provide smooth operation, minimize the wear of parts, and prevent malfunctions.

Periodic maintenance of this family of STI handguns involve cleaning and lubrication whenever any of the following conditions exist:

1. Before firing you STI handgun for the first time.
2. After disassembling the firearm. Disassembly removes lubrication from the moving parts and requires that you properly apply a high-quality lubricant intended for semi-automatic handguns upon reassembly.
3. After shooting the firearm. Clean and lubricate the handgun to prevent corrosion and reduce friction on moving parts caused by powder deposits that accumulate during shooting.
4. Before and after storing the handgun for more that a month. Firearms which have been stored for long periods of time accumulate deposits of dust, dirt and sometimes rust and other corrosive actions caused by the environment.
5. After the handgun becomes wet or dirty. Excessive moisture of dirt within the firearm and around it can create obstructions, causing an unsafe shooting condition.

WARNING!
Always empty a firearm before cleaning. Be certain to remove the magazine and any ammunition in the firearm's chamber before cleaning. Note: STI model handguns must be checked first by removing that magazine from the firearm to prevent a round from entering the chamber.

HANDGUN MAINTENANCE - CLEANING

Properly cleaning and lubricating firearms requires a basic set of tools and supplies. Your STI handgun is a precision assembly. Only high-quality tools and supplies should be used when working on it.

Tools:
• Bronze Bore-Cleaning Brush to remove heavy bore deposits from the barrel
• Handgun Bore Cleaning Rod with Threaded End to receive Cleaning Accessories
• Slotted Tip to hold Cleaning Patches
• Nylon Bristle Brush

Supplies:
• Cleaning Patches - 100% Cotton Flannel Cloth
• Cleaning Rags - 100% Cotton Flannel Cloth
• High-Quality Cleaning Solvent
• High-Quality Gun Oil * (available through STI International)
* Also required before shooting the handgun for the first time.

Procedure:
Cleaning your STI handgun should be done in the following manner.

1. Disassemble your STI handgun (Pages 22 through 30)
2. Clean and lubricate (Page 33)
3. Reassemble the handgun by reversing the disassembly procedure (Pages 22 through 30)

HANDGUN MAINTENANCE
CLEANING INSTRUCTIONS

1. Clean slide using a nylon brush and cleaning solvent; scrub away any powder residue, particularly on the slide rails. Wipe slide clean with a lint-free cotton cloth. Inspect the slide for damage or signs of unusual wear.

2. Clean frame with a nylon brush and cleaning solvent; scrub away any powder residue, particularly on the frame rails. Wipe frame clean with a lint-free cotton cloth. Inspect the frame for damage or signs of unusual wear.
3. Saturate a cotton pad with cleaning solvent and attach it to the bore cleaning rod; make several passes through the bore with the pad to saturate and loosen metallic and powder residues. Allow the barrel to soak for a few moments, then attach the bore brush to the bore cleaning rod, saturate the bristles with cleaning solvent, and make several passes through the bore with the bore brush. Inspect the bore for residues and repeat cleaning with the bore brush as necessary. **Note:** Always keep the bore brush saturated with cleaning solvent to prevent damage to the bore and/or compensator, and make each pass through the barrel a complete pass starting at the breach end of the barrel and continuing until the entire bristle section of the bore brush is outside the barrel or compensator – do not change directions when the brush is inside the barrel or compensator. Once the bore is free of residues, attach a clean cotton pad to the bore cleaning rod, saturate it with cleaning solvent and make several passes though the bore. Continue changing pads until the pad emerges clean. Finally, dry the bore with a clean cotton pad, apply a very small amount of high-quality lubricant to a clean cotton pad and make several passes through the barrel to lubricate it.
4. Clean all springs, pins and other components with cleaning solvent and wipe them dry with a lint-free cotton cloth. Inspect each part for damage or signs of unusual wear.
5. Apply a light coating of high-quality lubricating oil to all moving parts and reassemble the handgun. To reduce the possibility of corrosion, apply a very light coating of lubricating oil to all external steel parts.

Note: If any handgun components show signs of damage or unusual or excessive wear, stop using the firearm immediately and contact your gunsmith or STI International for assistance.

HANDGUN MAINTENANCE
FACTORY SERVICE

WARNING!
Always unload any firearm before packaging the firearm for repairs or service. Note: STI model handguns must be checked by first removing the ammunition magazine from the firearm to prevent a round from entering the chamber. Never ship ammunition with any firearm.

Requesting factory service…
Should your STI International handgun require service by the factory technicians, please contact STI International and discuss that problem you're having. In the event you must return your handgun to the factory for service, follow these shipping instructions.

1. Provide a written statement in as much detail as possible, describe the apparent problem or need for which you wish to have service rendered.
2. Carefully package your STI handgun, the written statement, and an empty ammunition magazine inside a sturdy, plain cardboard carton. Use quality protective packing as required to prevent damage to the handgun and magazine from movement during shipping.
3. Tape the carton shut securely using quality shipping tape, or use another acceptable method of sealing the carton, to prevent accidental opening during shipment.
4. Be certain to address that package clearly and include a return address that can receive packages.
5. Insure the package to protect the contents from damage, loss or theft. STI International cannot be held responsible for damage or loss incurred during shipment.
6. Ship the package via a reputable carrier with package tracking. DO NOT SHIP ANY FIREARM via US MAIL. It is unlawful.

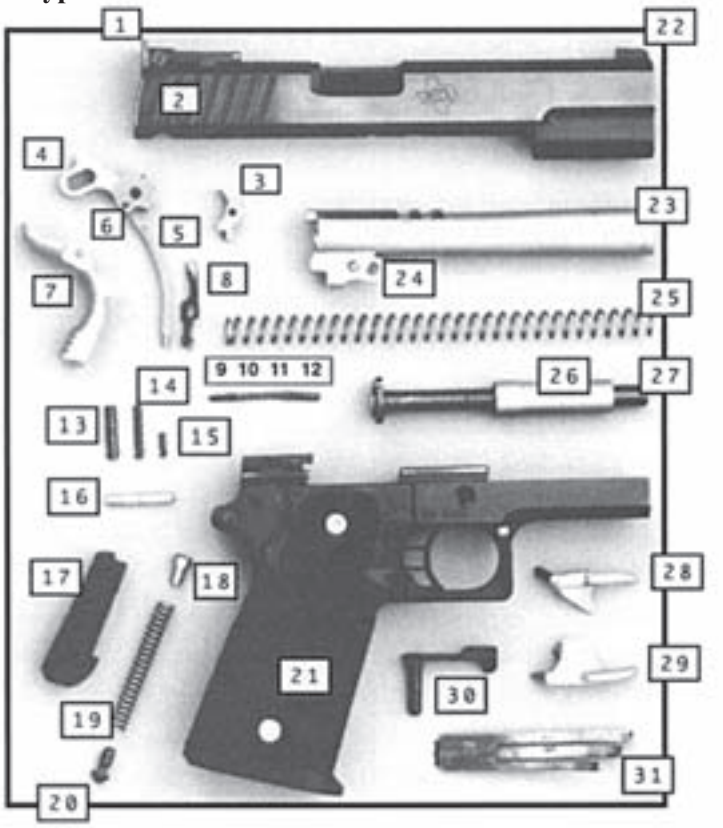
Notice of NO Written Warranty

Due to the complexities of complying with federal warranty law, STI International offers **no expressed or written warranty** on its products. We continually strive to stand behind out products and satisfy our customers, but we cannot make guarantees or warranties of any kind. Please contact us immediately should you experience a problem with any of our products.

Disclaimer

STI International expressly disclaims any liability for incidental or consequential damages. STI International firearms are intended for use exclusively with factory-specification standard velocity ammunition.

Typical Parts Breakdown - STI "1911/2011" Series



1 **Rear Sight (Bo-Mar‘ shown)**
2 **Slide**
3 **Sear**
4 **Hammer**
5 **Hammer Strut**
6 **Strut Pin**
7 **Beaver Tail**
8 **Disconnector**
9 **Slide Stop Plunger Tube Pin**
10 **Plunger Tube Spring**
11 **Safety Plunger Tube Pin**
12 **Plunger Tube Assembly**
13 **Hammer Pin**
14 **Sear Pin**
15 **Mainspring Cap Pin**
16 **Mainspring Housing Pin**
17 **Mainspring Housing**
18 **Mainspring Cap**
19 **Mainspring**
20 **Mainspring Housing Pin Retainer**
21 **Frame Unit (with Trigger, Trigger Guard & Mag Release)**
22 **Front Sight (‘Dove Tail’)**
23 **Barrel**
24 **Barrel Link & Link Pin**
25 **Recoil Spring**
26 **Guide Rod Spring Cap**
27 **Guide Rod**
28 **Safety, Right Side**
29 **Safety, Left Side**
30 **Slide Stop**
31 **Leaf Spring**

Owner Notes and Additional Information

Owner Notes and Additional Information (cont.)

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